

Work Order ID 62344

Monday, September 27, 2010 11:38:16 AM



Page 1

Item ID: D4155-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-9-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4155	A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

304 . . SSX 12.

2-Deburr if necessary

HB 16-10-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

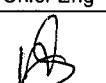
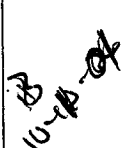

Quality Control

HB 16-10-21

pho ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4155-1 PAR #: _____ Fault Category: Small Fab/W-Jet NCR: Yes No DQA: _____ Date: 10/11/08
 Resolution: scrap Disposition: scrap QA: N/C Closed: _____ Date: 10/11/08

NCR: <u>62344</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/26	# 100	.080" Dim was cut too thin. From .040" to .030" on water jet RC: taper in cutting thick mat. and Part move due to pressure from cutting	 aggr	-Scrap + Destroy + Replace qty x3 mk <u>113762</u>	 10/11/08	S 10/11/08	 aggr	S 10/10/26
		RC: process						

NOTE: Date & initial all entries

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Page 2

Item ID: D4155-1

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Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 9/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(X4)	(3)		
130 Large Fab Large Fab	Weld per dwg A/R Hardcoat steel Batch: _____ M115872 Memo	0.00 0.00				12	10-11-4. 10-10.		(X4)
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							Pl 10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62344

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Page 3

Item ID: D4155-1

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 9/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(+4)			
160 Packaging Packaging	Identify as per dwg & Stock Location: <i>N/O</i> Memo <i>63330</i>	0.00 0.00				<i>EZ</i>	<i>10-11-4</i>	<i>24</i>	
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/11/05</i> <i>MF</i> <i>10-11-5</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 27, 2010 11:38:24 AM

Page 1

Work Order ID: 62344

Parent Item: D4155-1

Parent Item Name: Bar



Start Date: 9/27/2010

Required Date: 10/4/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X012.000		Purchased	No			100	sf	2.9410	1.27	2.673684			
304 BAR .500 X 12.00													

HB 10-10-01

Location

Loc Qty

Loc Code

MAT53

2.941

112778

2.941

m 304B0.500x2.500

304 2 1/2" X .5"

~~112778~~
112764

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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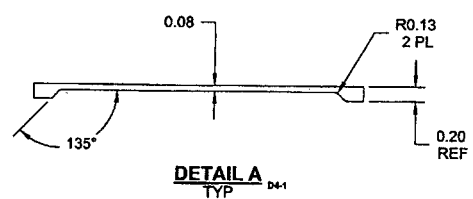
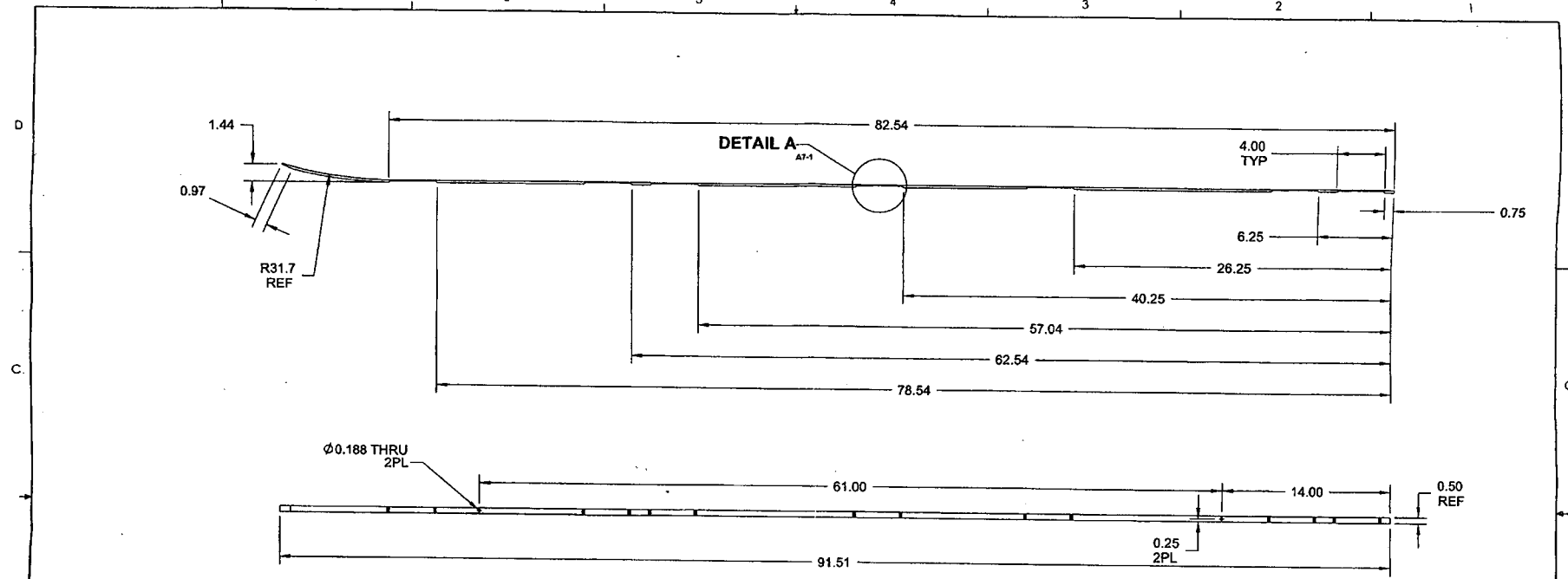
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4155-1 BAR

RELEASED
2010-09-15
MM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62344
PL 1092

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK PER ASTM A276 (REF. DART SPEC. M304B)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.16 lbs

A		NEW ISSUE		DESCRIPTION		SC	10.07.22
REV.						BY	DATE
DESIGN		SC		DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN		SC					
CHECKED				DRAWING NO.		REV. A	
MFG. APPR.				D4155		SHEET 1 OF 1	
APPROVED				TITLE		SCALE	
DE APPR.				BAR		NTS	
DATE				10.07.22			

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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